

Work Order ID 61790

Friday, September 03, 2010 10:13:40 AM



Page 1

Item ID: D3784-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Support Assembly, LH

Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3784

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 11/02/14

(2)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3784□****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented up****□****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented AFT****

SB 11/02/14

(2)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/02/15

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3784-043

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Required Date: 9/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 244

0.00



Packaging

Memo

0.00

Packaging

11/2/13 20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/02/16
MF
11-02-15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, September 03, 2010 10:13:45 AM

Page 1

Work Order ID: 61790

Parent Item: D3784-043

Parent Item Name: Seat Support Assembly, LH

Start Date: 9/3/2010


Required Date: 9/13/2010

Start Qty: 4.00



Required Qty: 4.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN525-10R20  Screw		Purchased	No			110	Each	106.0000	4	16		11/02/14	
---	--	-----------	----	--	--	-----	------	----------	---	----	--	----------	--



Location	Loc Qty	Loc Code
ST325	106	
113524	0	
114227	6	
114348	50	
114354	50	

 AN960JD10L  Washer	NAS1149D0332J	Purchased	No			110	Each	2,471.000	4	16		11/02/14	
---	---------------	-----------	----	--	--	-----	------	-----------	---	----	--	----------	--

Location	Loc Qty	Loc Code
ST348	2471	
110985	2471	

 D3763-041  End Fitting Assembly		Manufactured	No			110	Each	7.0000	2	8		11/02/14	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
ST251	3	
55380	1	
60456	2	
ST251A	4	
57929	4	

 D3763-043  End Fitting Assembly, LH		Manufactured	No			110	Each	0.0000	1	4		11/02/14	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

B 61784

 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, September 03, 2010 10:13:45 AM

Page 2

Work Order ID: 61790

Parent Item: D3784-043

Parent Item Name: Seat Support Assembly, LH

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 4.00

Required Qty: 4.00

D3770-1 Manufactured No 110 Each 9.0000 1 4

 Tube



SA 11/02/14

Location	Loc Qty	Loc Code
ST248A	9	
56569	9	


D3770-3 Manufactured No 110 Each 7.0000 1 4

 Tube



SA 11/02/14

Location	Loc Qty	Loc Code
ST254	7	
54318	7	

MS21042L3 Purchased No 110 Each 2,109.000 4 16

 Nut



SA 11/02/14

Location	Loc Qty	Loc Code
ST300	2109	
114523	109	
114784	2000	

4115835

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41790
2810-9-03

D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	HS	D3784	SHEET 1 OF 5
MFG. APPR.	HS	TITLE	SCALE
APPROVED	HS	SEAT SUPPORT ASSEMBLY	NTS
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DATE	08.06.23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

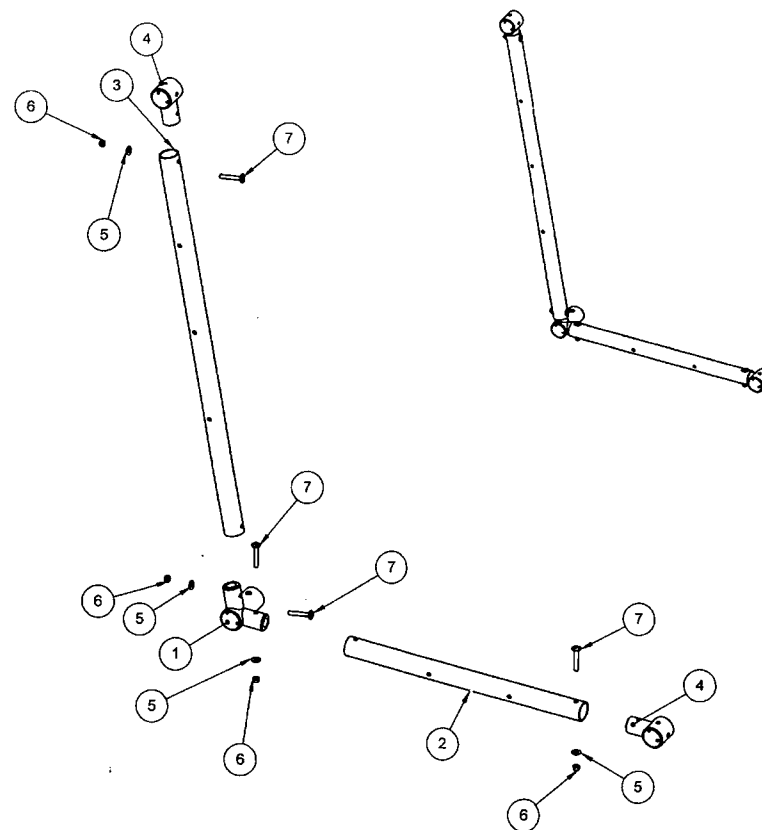
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

△
B
△
B
△
B



D3784-043 SEAT SUPPORT ASSY, LH

W/C 61798

RELEASED
11/08/07

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>NO</i>	D3784	SHEET 2 OF 5
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>NO</i>	SEAT SUPPORT ASSEMBLY	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALITY BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

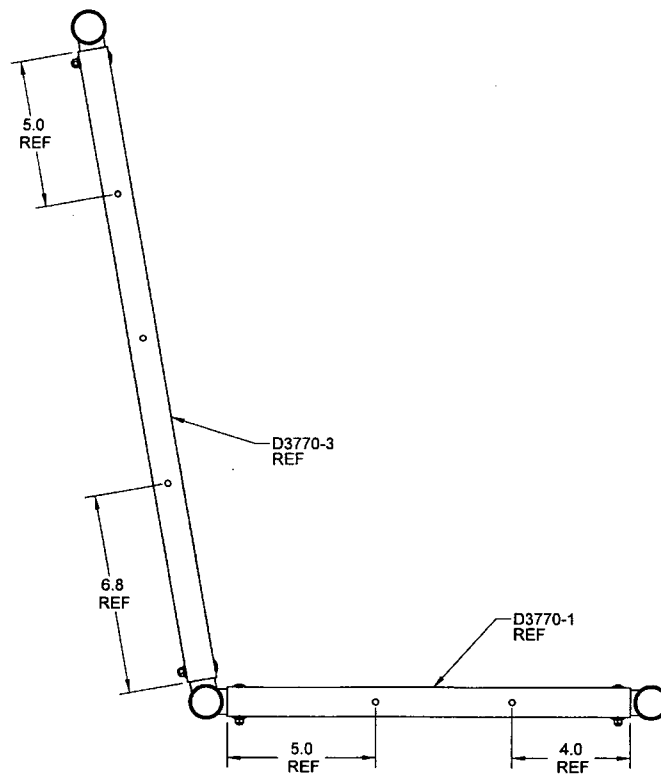
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3784-043 SEAT SUPPORT ASSY, LH

w/loc 1790

08-07-10 1/17

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3784	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

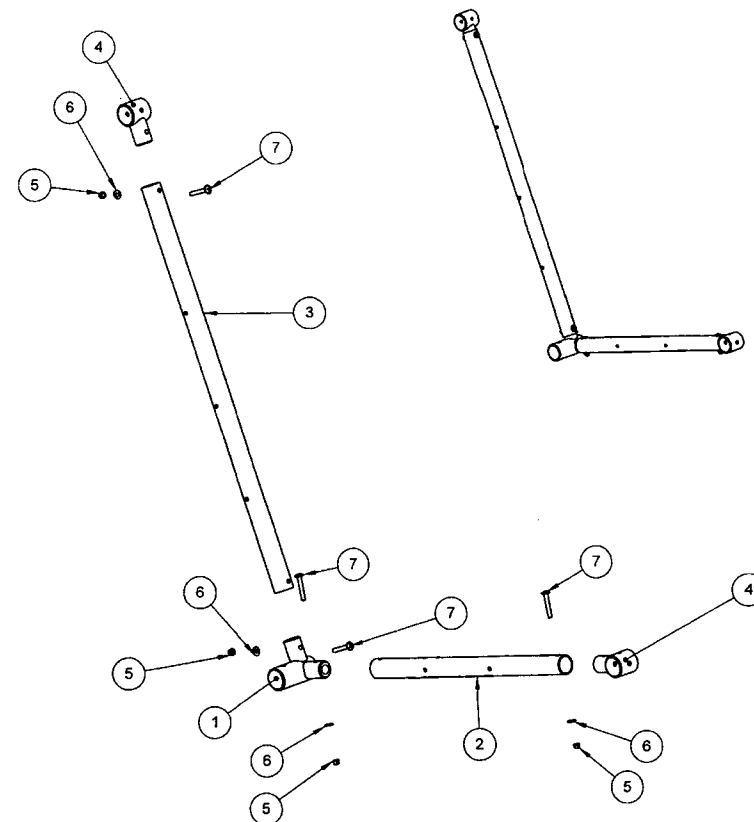
D

C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4



D3784-044 SEAT SUPPORT ASSY, RH

w/o 91790

RELEASED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3784	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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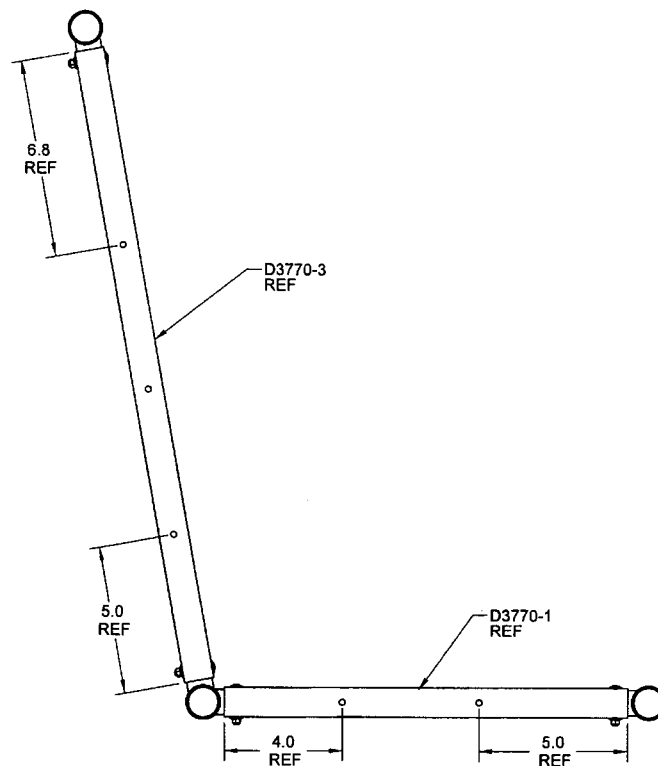
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NOTE: Date & initial all entries



D3784-044 SEAT SUPPORT ASSY, RH

w/o 41790

RELEASED
08 07 10 MPA

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 5 OF 5
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